

Date: Monday, 4/30/2007 7:24:19 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 32118		
Estimate Number	: 10512		
P.O. Number	: N/A	Part Number	: D26511
This Issue	: 4/30/2007 S.O. No. : N/A	Drawing Number	: D2651 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 31788	Material	: N/A
	Type : MACHINED PARTS	Due Date	: 5/4/2007
Written By	: <u>JA 07.04.30</u>	Qty:	44 Um: Each
Checked & Approved By	: <u>JA 07.04.30</u>		
Comment	: Est: A 02.04.15 New Issue NG Est: B 05.12.12 added deburr EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.0421 f(s)/Unit Total : 1.8526 f(s)  
 Material: 6061-T6 (QQ-A-225/8) 0.500" Dia  
 (M6061T6R0500)  
 Batch: M104187

MS 07/06/23

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HAAS CNC VERTICAL MACHINING #1  
 1- Turn as per Folio FA219 and Dwg D2651  
 2- Deburr

MS 07/06/25

(44)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/06/25

(44)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS 07/06/25

(44)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr ias per dwg D2651

SAP 07/07/04

(45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 5 Date: 07/07/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(45)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR/M/07-07-04

7.0

SPRAY PAINTING

SPRAY PAINTING



P/O: 4/05 C207/07/05 (45)

Comment: SPRAY PAINTING

PRIME

SPRAY PAINT DELFLEET BLUE

8.0

QC14

INSPECT SPRAY PAINT



207-11

Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/7/11 50

(45X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(45)

Comment: FINAL INSPECTION/W/O RELEASE

207/07/10

Job Completion



u 07-07-12

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



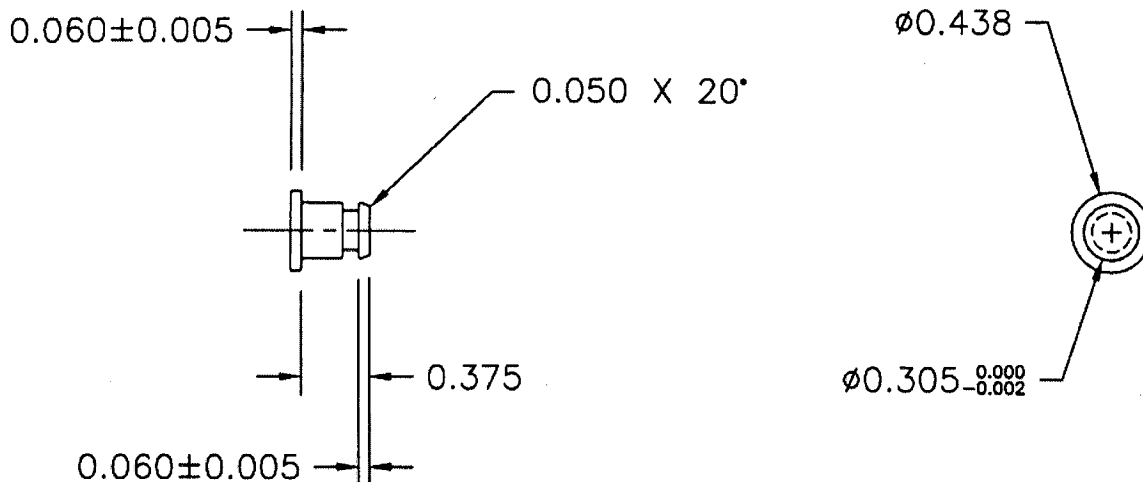


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

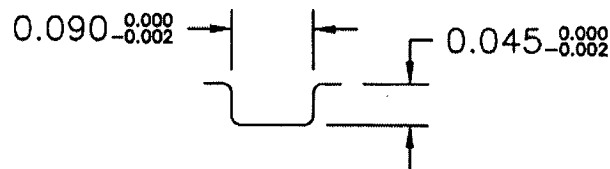
RELEASED

03.12.19

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32118

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